Work Order ID 109455

November-21-13 2:28:14 PM

109455

Item ID: D2810-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 11/21/13 **Start Qty:** 4.00 *4*

Required Date: 11/21/13 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-11-25 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2810	Revision Nbr: Rev C								
100	NC BRAKE	0.00				(4) SAO ~~3~~ 1. 14/01/07			
100									
Brake NC	**Memo**	0.00							
Brake NC	1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00				4			DAS 27 9-89
110									
QC	**Memo**	0.00							
Quality Control									
120	Black Sandtex(Ref:4.3-5.7) per QS1005 4.3 M126898.	0.00				H. ϕ 14-1-9			DAS 34 9-89
120									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 9:30 OVEN TEMPERATURE: 320° FINISH TIME: 10:00.								

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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Revision ID: **Stop** *NS2*
Item Name: Strut

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Required Date: 11/21/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00				4			DAS 27 9-89
130									
QC	**Memo**	0.00							
Quality Control									
140	Identify as per dwg & Stock Location:_____	0.00							
140									
Packaging	**Memo** 5253	0.00				14/01/10	(4)		DAS 32 9-89
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150							14-01-10		
QC	**Memo**	0.00							
Quality Control						14-01-10			

DQA: _____ Date: _____

DART AEROSPACE

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Part No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Mislabeled
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

November-21-13 2:28:14 PM

Work Order ID: 109455

Parent Item: D2810-5 **Start Date:** 11/21/13 **Required Date:** 11/21/13

Parent Item Name: Strut **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP A04.11.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	294.7058	1.9175	8.0736844	SAD	12/01/07	

Location	Loc Qty	Loc Code	
MAT017	294.7058225		
118702	0.00003		
123303	138.9645		
125513	86.1014525		8.0737
m126922	69.63984		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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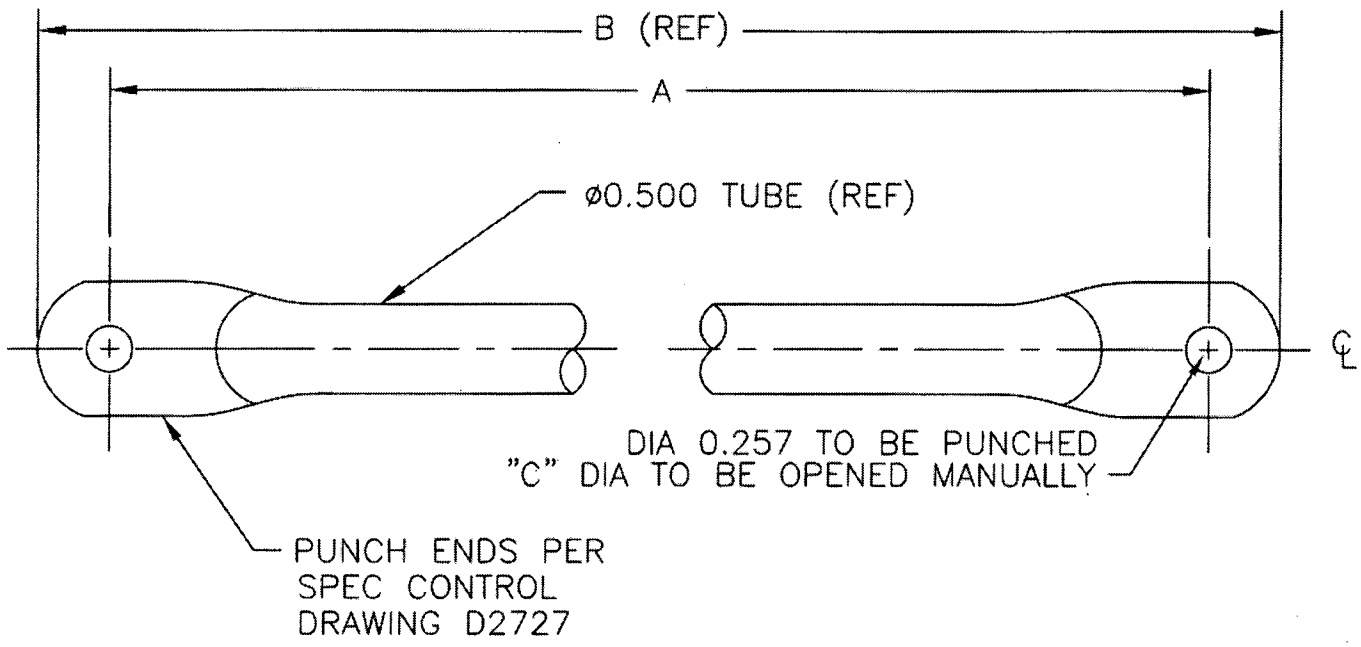
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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2810 — REV. C — SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT — SCALE NTS

A	00.11.08	NEW ISSUE
B	03.09.11	ADD FINISH
C	04.11.22	ADD −5

RELEASED
05.03.11



PART #	A	B	C
D2810−1	25.33	26.13	N/A
D2810−3	24.60	25.40	N/A
D2810−5	23.01	23.81	0.266

250
24.06

10 9455 13-11-25

D2810−1/−3/−5

1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, ø0.500 x 0.035 WALL (M304TR0.500W.035)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD

Description:	D2810-5 Strut.	Work Order:	109455
Inspection Drawing:	D2810-5	Rev: C	Part Number: D2810-5

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.01	+/-0.030	23.03	✓		M-T	SFAB-21
23.81	+/-0.030	23.81	✓		M-T	SFAB-21
0.266	+/-0.010	0.266	✓		Vern	SFAB-08

Measured by:	Checked By:	QC inspector	Engineering Approval (*if necessary*):
SAD	DAS 30 ~~9-89~~	DAS 27 ~~9-89~~	
Date 14/01/07	Date 14/01/07	Date 14/1/7	Date